

# Work Order ID 91264

October-05-12 9:11:56 AM

**\*91264\***

Page 1

Item ID: 647.0112 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Strut Bracket  
 Start Date: 10/04/12 Start Qty: 98.00 **\*98\*** Cust Item ID:  
 Required Date: 10/31/12 Req'd Qty: 98.00 **\*98\*** Customer:  
 Reference:

Approvals: Process Plan: MLS Date: 12-10-05 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|-----------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| <b>Draw Nbr</b>                | <b>Revision Nbr</b>                     |                      |         |        |              |               |               |                  |                |
| 647.0100                       | A                                       |                      |         |        |              |               |               |                  |                |
| 100                            | FLOW WATER JET                          | 0.00                 |         |        |              |               |               |                  |                |
| <b>*100*</b>                   |                                         |                      |         |        |              |               |               |                  |                |
| Waterjet                       | Memo                                    | 0.00                 |         |        |              |               |               |                  |                |
| FLOW CNC Waterjet              | 1-Cut as per Dwg                        |                      |         |        |              |               |               |                  |                |
| <u>304 .080</u>                | Dwg Rev: <u>A</u>                       |                      |         |        |              |               |               |                  |                |
|                                | Prog Rev: <u>A</u>                      |                      |         |        |              |               |               |                  |                |
|                                | 2-Deburr if necessary                   |                      |         |        |              |               |               |                  |                |
| 110                            | QC2- Inspect parts off machine FAI/FAIB | 0.00                 |         |        |              |               |               |                  |                |
| <b>*110*</b>                   |                                         |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                                    | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                         |                      |         |        |              |               |               |                  |                |

100 0 Jm 12-10-13

100 0 Jm 12-10-13

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Page 2

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Revision ID: Stop **\*NS2\***  
Item Name: Strut Bracket  
Start Date: 10/04/12 Start Qty: 98.00 **\*98\*** Cust Item ID:  
Required Date: 10/31/12 Req'd Qty: 98.00 **\*98\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID               | Operation<br>Description                                  | Set Up/<br>Run Hours | Tool ID | Tool #                     | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|----------------------------------------------|-----------------------------------------------------------|----------------------|---------|----------------------------|--------------|---------------|---------------|------------------|----------------|
| 120<br><b>*120*</b><br>QC<br>Quality Control | QC8- Inspect parts - second check<br><br>Memo             | 0.00<br>0.00         |         | Smb<br>12016               |              | 101<br>con    |               |                  |                |
| 130<br><b>*130*</b><br>Brake NC<br>Brake NC  | Form as per dwg<br>NC BRAKE<br><br>Memo                   | 0.00<br>0.00         |         |                            |              | 101           | 0             |                  | Jm1309-25      |
| 140<br><b>*140*</b><br>QC<br>Quality Control | QC5- Inspect part completeness to step on W/O<br><br>Memo | 0.00<br>0.00         |         | DAS<br>27<br>9-89<br>13923 |              | 101<br>con    |               |                  |                |

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October-05-12 9:11:56 AM

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Item ID: 647.0112 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Strut Bracket  
Start Date: 10/04/12 Start Qty: 98.00 **\*98\*** Cust Item ID:  
Required Date: 10/31/12 Req'd Qty: 98.00 **\*98\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|-------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150                            |                                                             | 0.00                 |         |        |              |               |               |                  |                |
| <b>*150*</b>                   |                                                             |                      |         |        |              | 101           | 0             | 0                | AR             |
| SprayPaint                     | Memo                                                        | 0.00                 |         |        |              |               |               |                  | 13-9-29        |
| Spray Painting                 | PRIME AS PER DWG NOTE 6                                     |                      |         |        |              |               |               |                  |                |
|                                | PR-148 PRIMER BATCH: <u>126022</u>                          |                      |         |        |              |               |               |                  |                |
| 160                            | QC14- Inspect Spray Paint                                   | 0.00                 |         |        |              |               |               |                  |                |
| <b>*160*</b>                   |                                                             |                      |         |        |              | 101           |               |                  | 13-10-01       |
| QC                             | Memo                                                        | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                                             |                      |         |        |              |               |               |                  |                |
| 170                            | Identify as per dwg & Stock Location: <u>51535</u>          | 0.00                 |         |        |              |               |               |                  |                |
| <b>*170*</b>                   |                                                             |                      |         |        |              | 101           |               |                  | 13-10-01       |
| Packaging                      | Memo                                                        | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      | ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV*** |                      |         |        |              |               |               |                  |                |

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Item ID: 647.0112

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Strut Bracket

Start Date: 10/04/12 Start Qty: 98.00

**\*98\***

Cust Item ID:

Required Date: 10/31/12 Req'd Qty: 98.00

**\*98\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

*[Signature]* / *Rm 13/10/02*  
*MLJ 13-10-01*



# Picklist Print

October-05-12 9:11:55 AM

Page 1 / 1

Work Order ID: 91264  
Parent Item: 647.0112  
Parent Item Name: Strut Bracket

Start Date: 10/04/12  
Start Qty: 98.00  
Required Date: 10/31/12  
Required Qty: 98.00

Comments: IPP REV:A 12.08.14 NEW ISSUE DD VERF:JFS

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S14GA  
304SS sheet .080

Purchased No

100 sf 40.7400 0.0325

3.3526316  
3.5

Jm 12-10-13

Location

Loc Qty

Loc Code

MAT020

40.74

117933

3.6

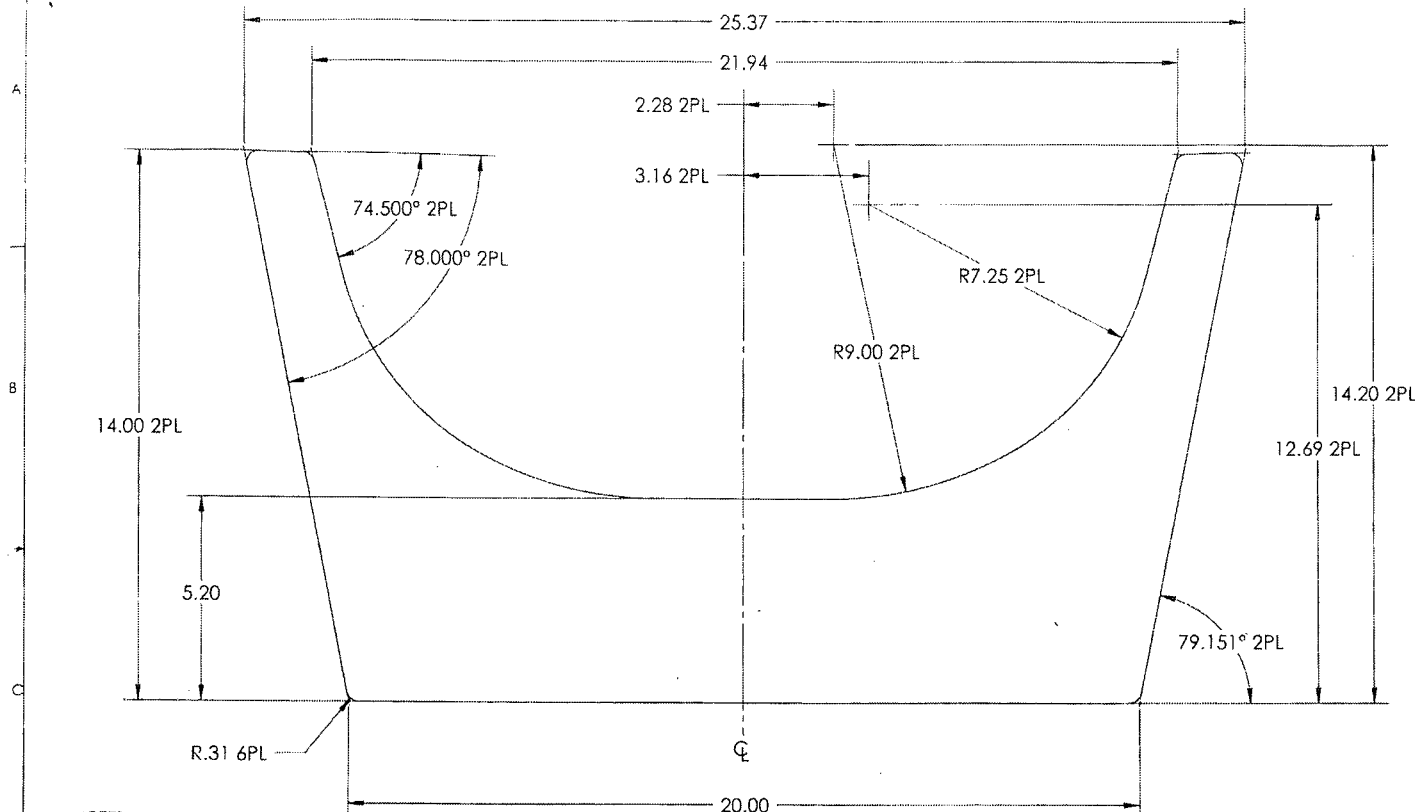
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37.14

119276

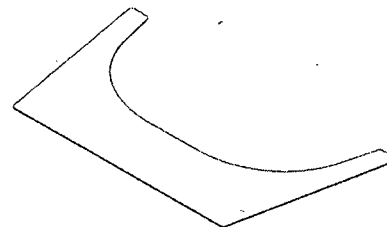
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| REV | DESCRIPTION           | DATE     | BY        | APP'D |
|-----|-----------------------|----------|-----------|-------|
| 1   | LAST PROJECT REVISION |          |           |       |
| 2   | INITIAL RELEASE       | 06/11/25 | P. BRANCO |       |
| 3   | PROJECT RELEASE       | 04/22/25 | P. BRANCO |       |



NOTES:

1. MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE I CLASS N.
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
5. MATERIAL: 304 SS IAW AMS 5643.
6. FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N.



647.0110

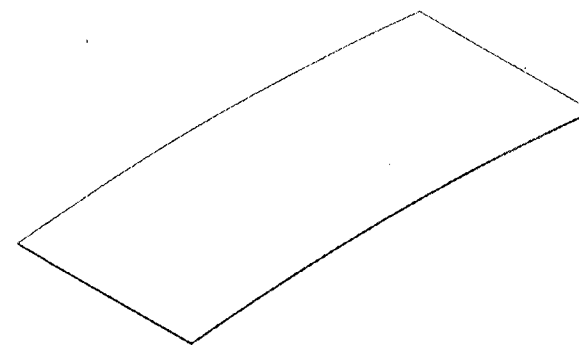
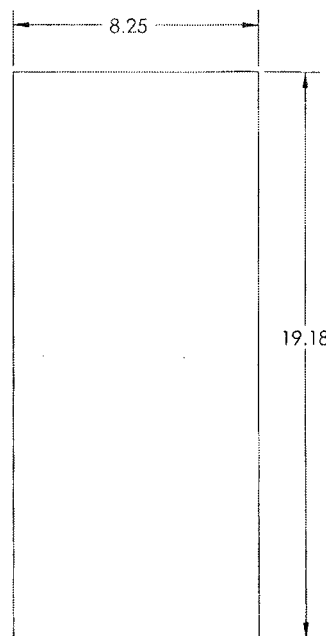
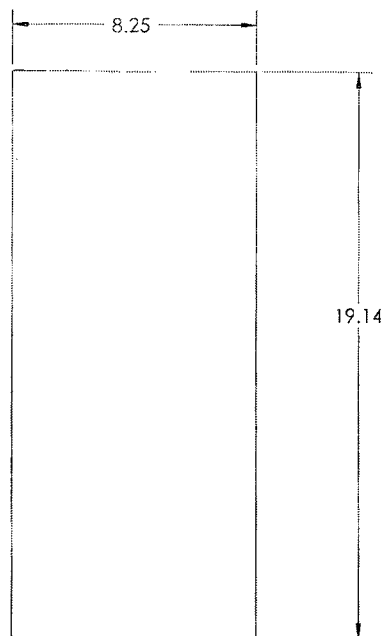
| QTY        | FIN # | PART #   | DESCRIPTION                              | MATL      | SPEC.        |
|------------|-------|----------|------------------------------------------|-----------|--------------|
|            |       | 647.0116 | DOUBLER                                  | △         | △            |
|            |       | 647.0115 | CLIP                                     | △         | △            |
|            |       | 647.0114 | CLIP                                     | △         | △            |
|            |       | 647.0113 | STRUT DOUBLER                            | △         | △            |
|            |       | 647.0112 | STRUT BRACKET                            | △         | △            |
|            |       | 647.0111 | PANEL                                    | △         | △            |
|            |       | 647.0110 | ROOF DOUBLER                             | △         | △            |
| PARTS LIST |       |          | APICAL INDUSTRIES                        |           |              |
|            |       |          | 2608 TEMPLE HEIGHTS DR.                  |           |              |
|            |       |          | OCEANSIDE, CA. 92056-3512 (760) 724-5300 |           |              |
|            |       |          | SHEETMETAL                               |           |              |
|            |       |          | SHEET                                    | CAGE CODE | DWG. NO.     |
|            |       |          | B                                        | 07M26     | 647.0100     |
|            |       |          | SCALE                                    | NONE      | SHEET 1 OF 6 |

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WITHOUT NOTICE  
WORK ORDER

NO. 91264 MLJ  
12-10-05

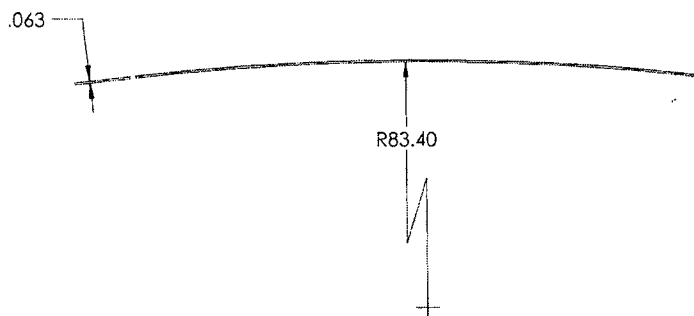
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647.0111

FLAT PATTERN



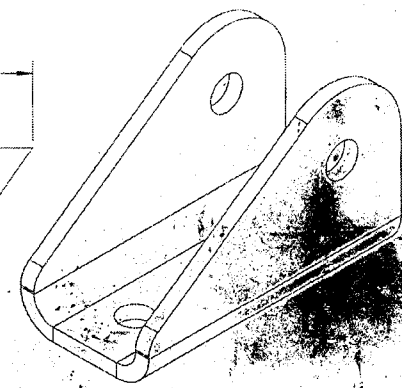
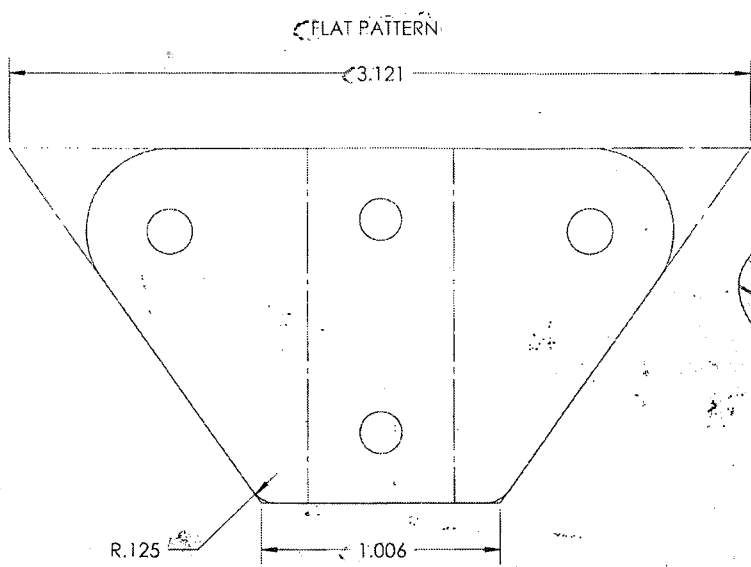
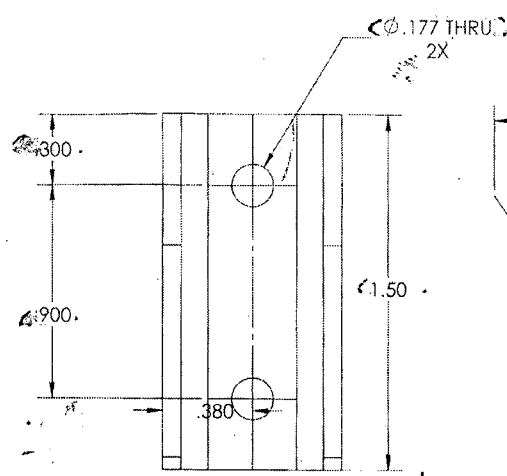
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| ORIGINAL DATE                                                                                                                                 |  | APICAL INDUSTRIES                        |        |
| DRAWN BY: P. ROSARIO                                                                                                                          |  | 2608 TEMPLE HEIGHTS DR.                  |        |
| CHECKED BY: P. ROSARIO                                                                                                                        |  | OCEANSIDE, CA. 92056-3512 (760) 724-5300 |        |
| DRAWING APPROVAL:                                                                                                                             |  | SHEETMETAL                               |        |
| CONTRACT NO.                                                                                                                                  |  | DWC. NO. 647.0100                        |        |
| UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES<br>TOLERANCES ARE:<br>2 PLACES DECIMALS ±.01<br>3 PLACES DECIMALS ±.005<br>ANGLES ± 5° |  | REV. A                                   | REV. A |
| SCALE: NONE                                                                                                                                   |  | SHEET 2 OF 6                             |        |



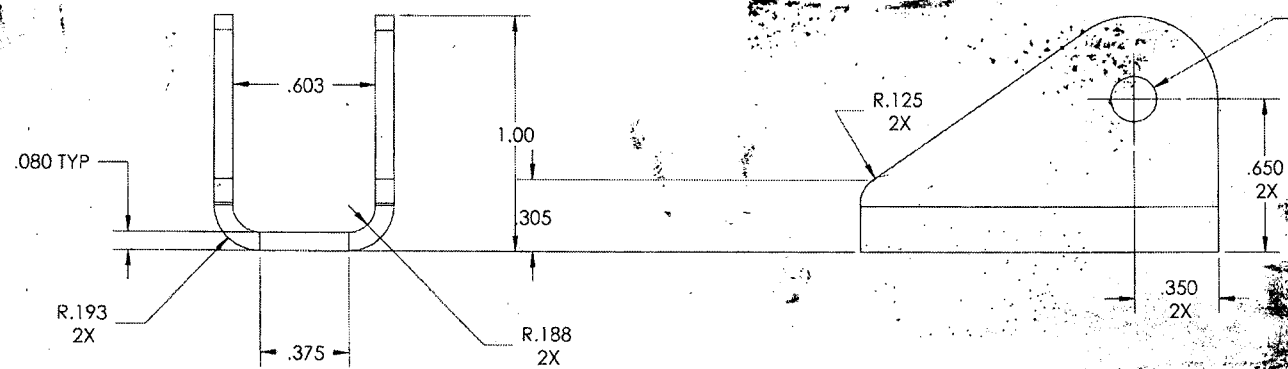
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647.0102



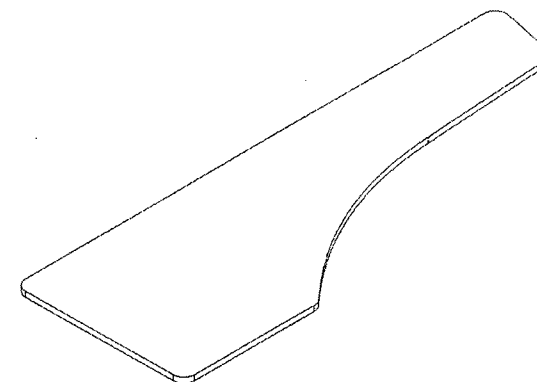
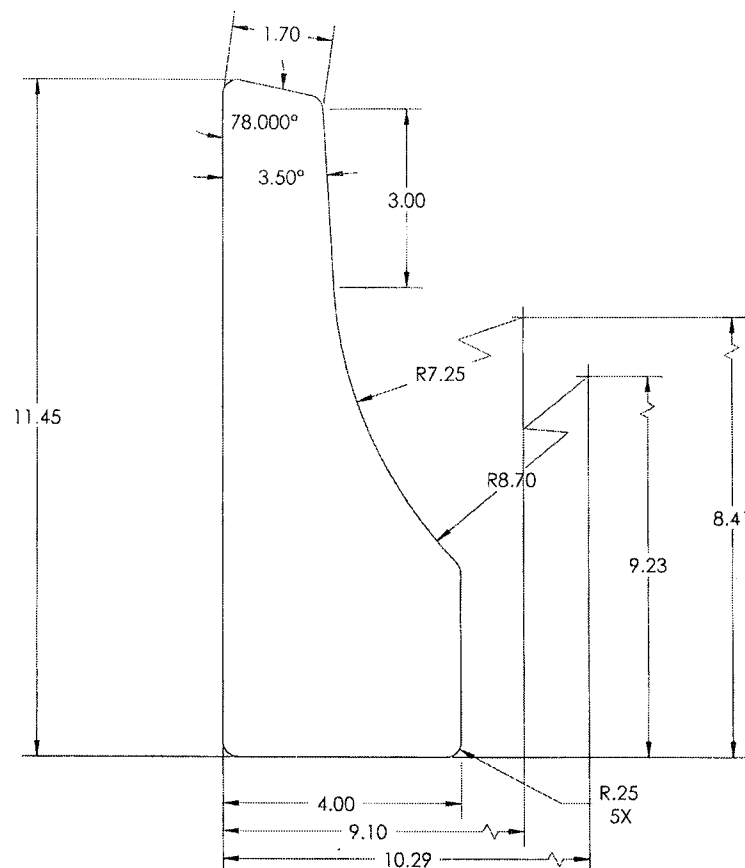
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| ORIGINAL DATE: 10/1/82<br>BY: [Signature]<br>CHECKED: [Signature]<br>APPROVED: [Signature]<br>CONTRACT NO.:                         |  | <b>APICAL INDUSTRIES</b><br>2208 TEMPLE HEIGHTS DR.<br>OCEANSIDE, CA 92056-3512 (760) 724-5300<br><b>SHEET METAL</b> |               |
| UNLESS OTHERWISE SPECIFIED,<br>DIMENSIONS ARE IN INCHES<br>TOLERANCES ARE AS SHOWN<br>3 PLACE DECIMALS & 0.001<br>ANGLES 1/2 DEGREE |  | SCALE: NONE                                                                                                          | SHEET: 3 OF 6 |



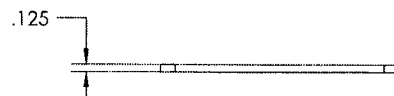
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647.0113

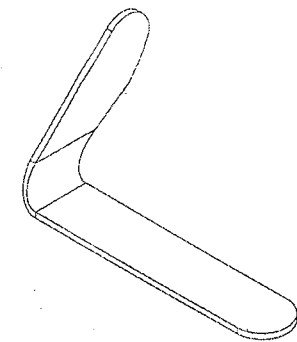
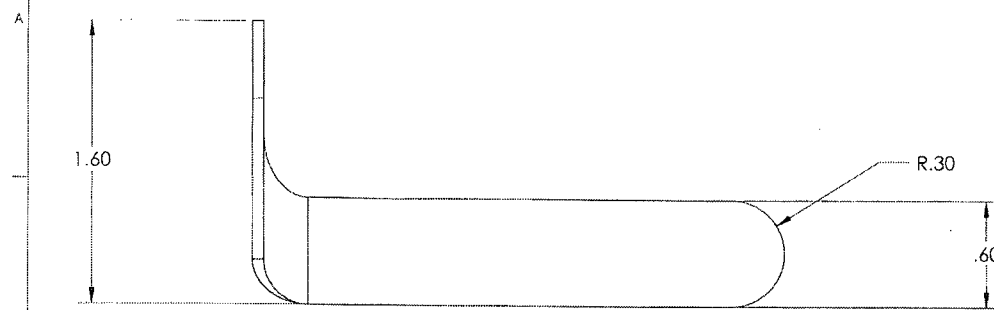


|                                                                                                                                                                                            |                          |                        |                                                                                         |          |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------|------------------------|-----------------------------------------------------------------------------------------|----------|
| ORIGINAL DATE<br>10/24/01                                                                                                                                                                  | DESIGNED BY<br>P. ROSANO | CHECKED BY<br>P. BRAVO | APICAL INDUSTRIES<br>2608 TEMPLE HEIGHTS DR.<br>OCEANSIDE, CA. 92056-3512 (760)724-5300 |          |
| DRAWING APPROVAL<br>P. BRAVO                                                                                                                                                               |                          |                        | SHEETMETAL                                                                              |          |
| UNLESS OTHERWISE SPECIFIED:<br>DIMENSIONS ARE IN INCHES<br>TOLERANCES ARE:<br>FRACTIONS DECIMALS<br>1/16" .0005 .001 .002 .005 .010 .015 .030 .060 .125 .250 .500 1.000 2.000 5.000 10.000 |                          |                        | REV<br>B                                                                                | REV<br>A |
| SCALE: NONE                                                                                                                                                                                |                          |                        | SHEET 4 OF 6                                                                            |          |

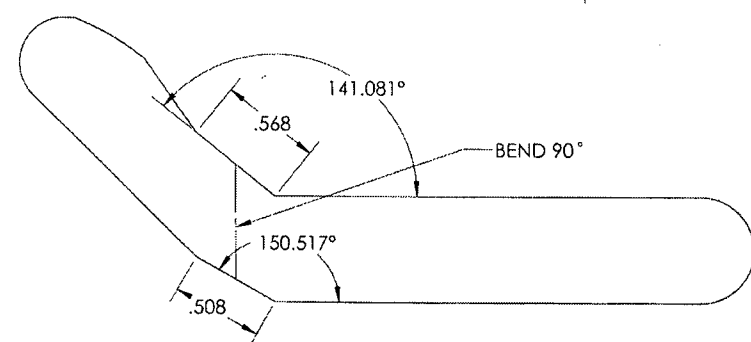
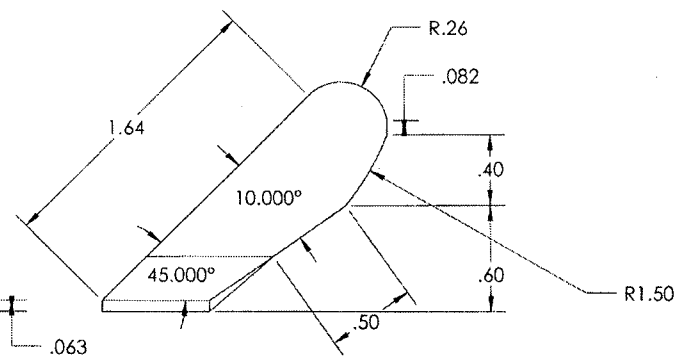
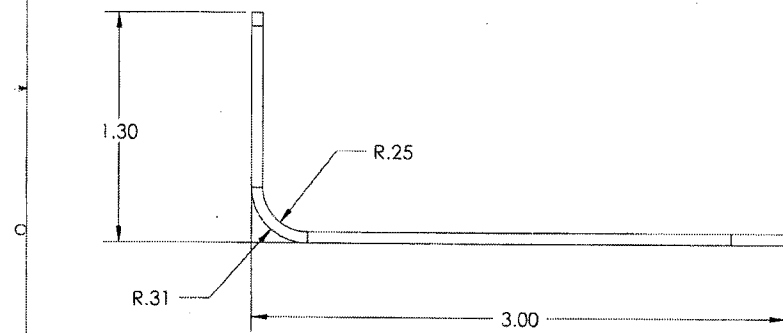
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|------|-------------|------|----------|
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91264



647.0114 SHOWN  
647.0115 OPPOSITE



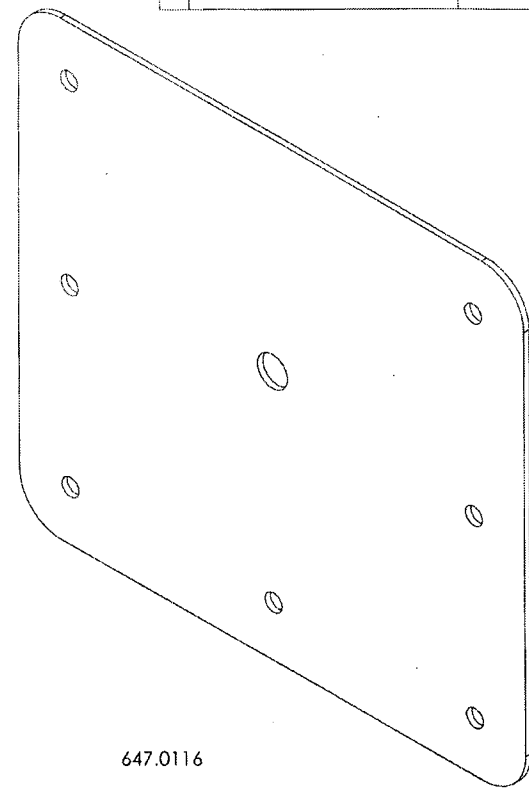
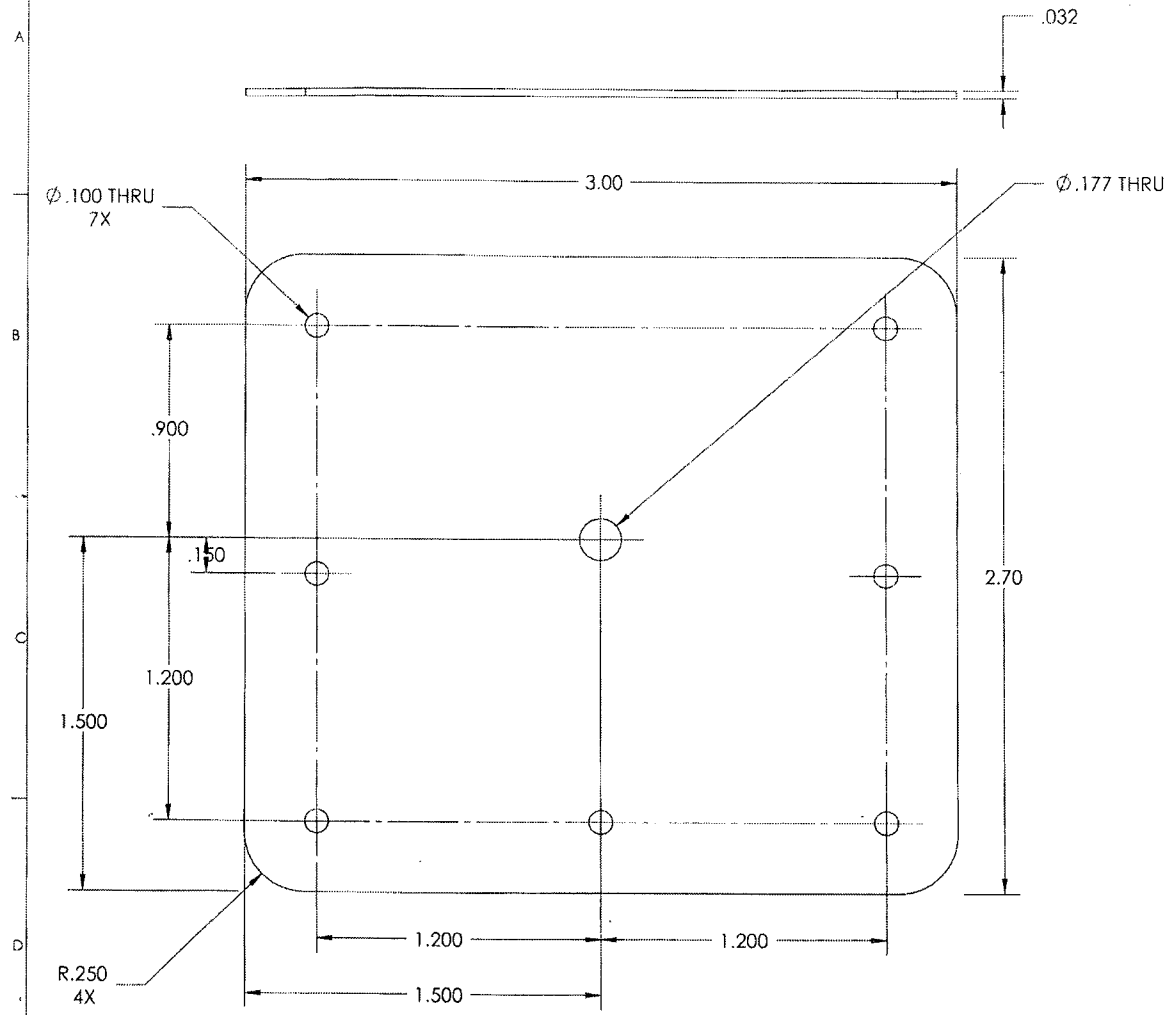
FLAT PATTERN

|                                                                                                                                                                                                                                                                  |  |                                                                                                |          |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------------------------------------------------------------------------|----------|
| <small>           ORIGINAL DATE<br/>           (DATE) (DATE)<br/>           DRAWN BY<br/>           R. ROMANO<br/>           CHECKED<br/>           P. ERANO<br/>           DRAWING APPROVAL<br/>           R. BRAY<br/>           CONTRACT NO.         </small> |  | <b>APICAL INDUSTRIES</b><br>2608 TEMPLE HEIGHTS DR.<br>OCEANSIDE, CA. 92056-3512 (760)724-5300 |          |
| <small>           UNLESS OTHERWISE SPECIFIED<br/>           DIMENSIONS ARE IN INCHES<br/>           TOLERANCES ARE:<br/>           1. FRACTIONS ± .01<br/>           2. DECIMALS ± .005<br/>           3. ANGLES ± .5°         </small>                          |  | SHEETMETAL<br>647.0100                                                                         | REV<br>A |
| SCALE: NONE                                                                                                                                                                                                                                                      |  | SHEET 5 OF 6                                                                                   |          |

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647.0116

|                                                                                                                                                  |  |                                                                                                |                        |
|--------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------------------------------------------------------------------------------|------------------------|
| ORIGINAL DATE: 05-28-80<br>DRAWN BY: P. KOSAKO<br>CHECKED BY: P. BRAVO<br>DRAFTER'S APPROVAL: P. BRAVO<br>CONTRACT NO: 05-28-80                  |  | <b>APICAL INDUSTRIES</b><br>2608 TEMPLE HEIGHTS DR.<br>OCEANSIDE, CA. 92056-3512 (760)724-5300 |                        |
| ANALYST DIMENSIONS SPECIFIED<br>DIMENSIONS ARE IN INCHES<br>TOLERANCES ARE:<br>2 PLACE DECIMALS ± .01<br>3 PLACE DECIMALS ± .005<br>ANGLES ± .5° |  | SHEETMETAL<br>SCALE: NONE                                                                      | REV. A<br>SHEET 6 OF 6 |

